

## Claims

What is claimed is:

1. An article of manufacture for a hollow one piece plastic injection molded bicycle frame comprising:
  - A. A hollow plastic injection molded bicycle frame comprising of the ability to attach a front fork assembly, a seat assembly, a pedal crank assembly and, rear wheel assembly;
  - B. A plastic injection mold to produce a bicycle frame that is one piece hollow and free from welding and brazing;
  - C. The ability to select from a verity of polymers (plastic resin) to produce a one piece hollow bicycle frame depending on the bicycling application,
  - D. A mold which produces a tin bismuth core of a bicycle frame; and
  - a plastic injection mold which produces a plastic bicycle frame..
2. A process for a hollow one piece plastic injection molded bicycle frame comprising the steps of:
  - A. A hollow plastic injection molded bicycle frame comprising of the ability to attach a front fork assembly, a seat assembly, a pedal crank assembly and, rear wheel assembly;
  - B. A plastic injection mold to produce a bicycle frame that is one piece hollow, and free from welding and brazing;

- C. The ability to select from a variety of polymers (plastic resin) to produce a one piece hollow bicycle frame depending on the bicycling application.;
- D. A mold which produces a tin bismuth core of a bicycle frame; and a plastic injection mold which produces a plastic bicycle frame..